

Date: Thursday, 02/04/2009 2:25:55 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WINDOW ASSEMBLY
Job Number	: 46851		
Estimate Number	: 10758		
P.O. Number	:	Part Number	: D3136041
This Issue	: 02/04/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3136 REV E
First Issue	: / /	Project Number	: N/A
Previous Run	: 44297	Drawing Revision	: E
	Type : THERMOFORMING	Material	:
Written By	:	Due Date	: 20/04/2009
Checked & Approved By	: <u>JUL 09 04:02</u>	Qty:	6 Um: Each
Comment	: Est B 04.02.04 Reformat KJ/DS Est. C Thermoform in house 05/07/2007 DL Est D Rev E 07.09.28 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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Comment: Qty.: 4.4625 sf(s)/Unit Total : 26.7750 sf(s)
 polycast II or plexiglass G .125"

110633 RB 9-4-15

2.0	WATER JET	FLOW WATER JET
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E
E
E

RB 9-4-15

**Comment:** FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 9-4-15

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

509/04/15 (x6)

5.0	THERMOFORMING	THERMOFORMING MACHINE
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**Comment:** 1-Thermoform as per Dwg D3136 and Folio FTA006

Dwg Rev. E
 Folio Rev. B.

2- Engrave Part # and Batch # , and affix labels
 (D3136-1)

BB 09/04/2009 (x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WINDOW ASSEMBLY

Job Number: 46851

Part Number: D3136041

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



P.T.O.

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check product for scratches mal-formation or any other non conformances.

BB 09/04/20 (X5)

7.0

QC8

SECOND CHECK



Comment: SECOND CHECK

S 09/04/20 (X5)

8.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

Water sand and buff to remove scratches as required

BB 09/04/20 (X5)

9.0

D31089

Decal



Comment: Qty.: 2.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part# Description Batch
2 D3108-9 Decal B 34554

BB 09/04/20 (X5)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/20 (X5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: S215

BB 09/04/27 (5)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/27

Job Completion



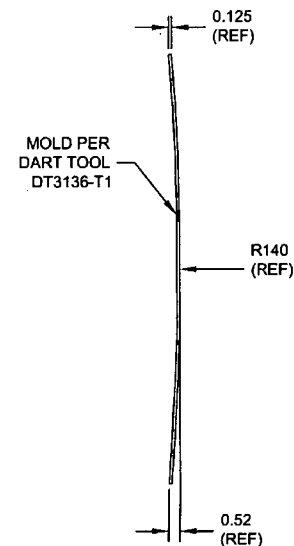
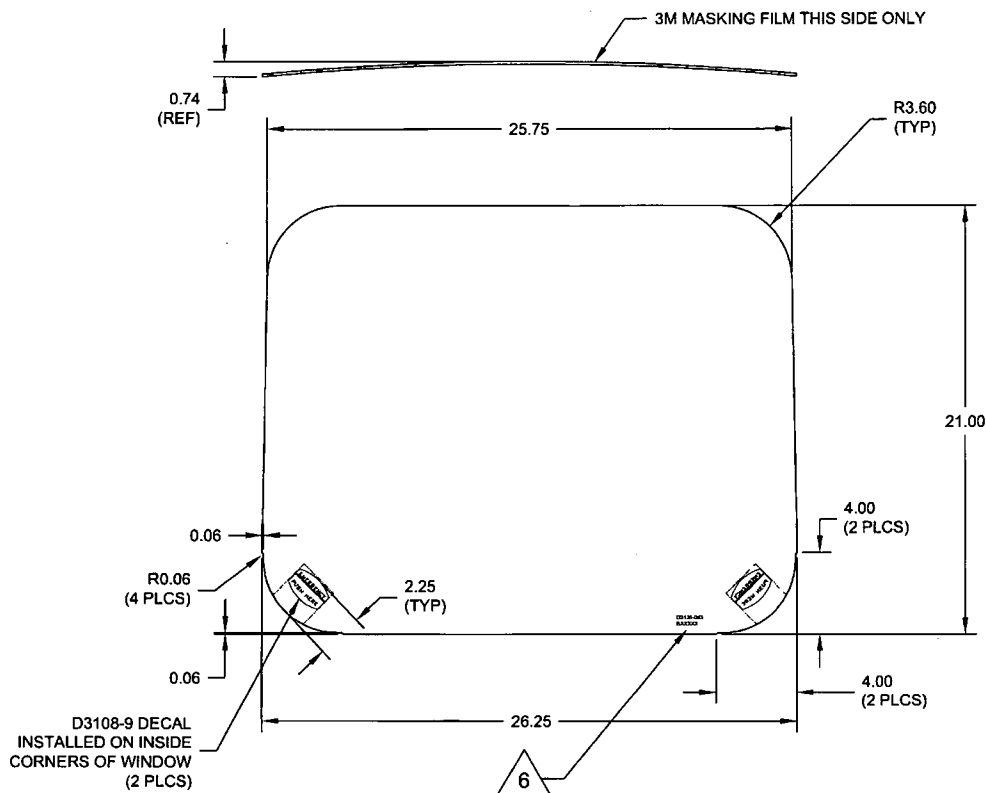
MF
09-04-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 09/04/28
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46851</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/22</u>	<u>6.2</u>	<u>NOTCH ON COVER OF WINDOW NOT CUT RC machine malfunction OAL set</u>	<u>[Signature]</u>	<u>Scrap & destroy Qty. 1 window. All remaining parts are good.</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>	<u>[Signature]</u>

NOTE: Date & initial all entries



D3136-3 WINDOW
D3136-043 WINDOW ASSEMBLY
 (INCLUDES D3108-9 DECALS)

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
 CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C, 0.125 THICK
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3136-043" AND B/N ON LOWER EDGE
 USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 2.61 +/- 0.58 LBS
- 8) FORMING PROCESS: a) HEAT LARGER PIECE TO 250° F
 b) DRAPE OVER D3136-T1 MOLD & CLAMP
 c) LEAVE FOR 2 HOURS COVERED WITH INSULATED BLANKETS

RELEASED
 07.09.22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D3136	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WINDOW ASSEMBLY	1:6
DATE	07.09.10	<small>COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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